

Date: Wednesday, 29/04/2009 3:02:30 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : DOOR ASSEMBLY
<b>Job Number</b> : 47612	
<b>Estimate Number</b> : 11403	
<b>P.O. Number</b> :	<b>Part Number</b> : D3296041 <b>BK</b>
<b>This Issue</b> : 29/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3296 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 45820	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/05/2009 <b>Qty:</b> 6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUL 09 04 29</u>	
<b>Comment</b> : Est. C 05.10.14 Added step 14 KJ/EC Est Rev:D Revised Steps 06-11-20 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D32961	Door Panel
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
1	D3296-1	Door Panel	<u>B47775</u>

2.0	D32963	Door Panel
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
1	D3296-3 Door Panel		<u>B47776</u>

3.0	D31617	Hinge 14.0"
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Hinge 14"

Batch: B45588(6x) B45842(3x)

4.0	D31619	Hinge 17.0"
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Hinge 17"

Batch: B47688

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 29/04/2009 3:02:30 PM  
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## Process Sheet

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Drawing Name: DOOR ASSEMBLY

Job Number: 47612

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 25.0000 Each(s)/Unit Total : 150.0000 Each(s)

Rivet, Universal Head

Batch: ~~M111793~~

M1109631

Ep09/05/27

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Fabricate & assemble as per Dwg D3296.

Ep09/05/27

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/27 (28)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 2:15pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 2:45pm

11 09-05-27 (29)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F 09/05/27 (9)

10.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Decal - No Step

Pick:

Qty Part Number Description Batch

1 D2137 Decal ~~D 2137~~ B 45851

FF 09-05-08 (6)

11.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Handle

Pick:

Qty Part Number Description Batch

1 D2419 Handle

B17678 X7  
B45639 X2

SS 09/05/28 (X9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: DOOR ASSEMBLY

Job Number: 47612

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2462

Seal



Comment: Qty.: 0.3333 f(s)/Unit Total : 1.9998 f(s)

Qty Part Number Description Batch

1 D2462 Seal

CUT ONE PIECE 4.00" LONG

37747

SS 09/05/28 (X9)

13.0

D2462

Seal



Comment: Qty.: 0.4420 f(s)/Unit Total : 2.6520 f(s)

Qty Part Number Description Batch

1 D2462 Seal

CUT ONE PIECE 5.30" LONG

37747

SS 09/05/28 (X9)

14.0

D2462

Seal



Comment: Qty.: 2.0420 f(s)/Unit Total : 12.2520 f(s)

Qty Part Number Description Batch

1 D2462 Seal

CUT ONE PIECE 24.50" LONG

37747

SS 09/05/28 (X9)

15.0

D27281

Dart Logo label



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Dart Logo label small

Pick:

Qty Part Number Description Batch

1 D2728-1 Decal

39012

SS 09/05/28 (X9)

16.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD6 Washer

M1085

SS 09/05/28 (X9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: DOOR ASSEMBLY

Job Number: 47612

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

MS20470AD48 S

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number S Description Batch

1 MS20470AD48 Rivet

M109371

88 09/05/08 (9)

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3296

FF 09-06-08 (9)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/06/08 (9)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51218

09/06/08 (9)

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/09 (9)

Job Completion



MF 09-06-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

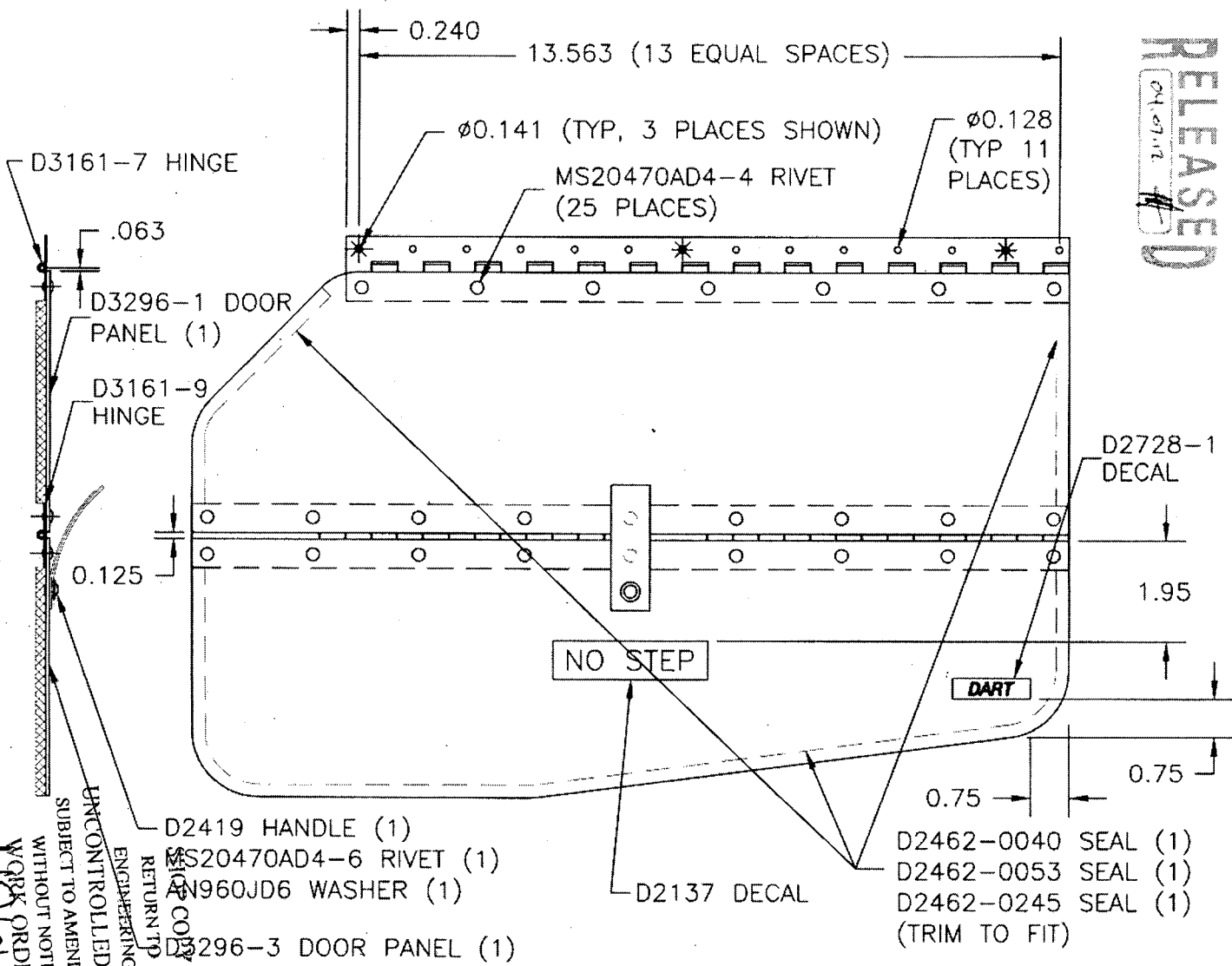
**NOTE:** Date & initial all entries





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DATE 04.06.28	DRAWING NO. D3296	REV. A
A	04.06.28	1 OF 2
	TITLE DOOR ASSEMBLY	SCALE 1:3
	NEW ISSUE	



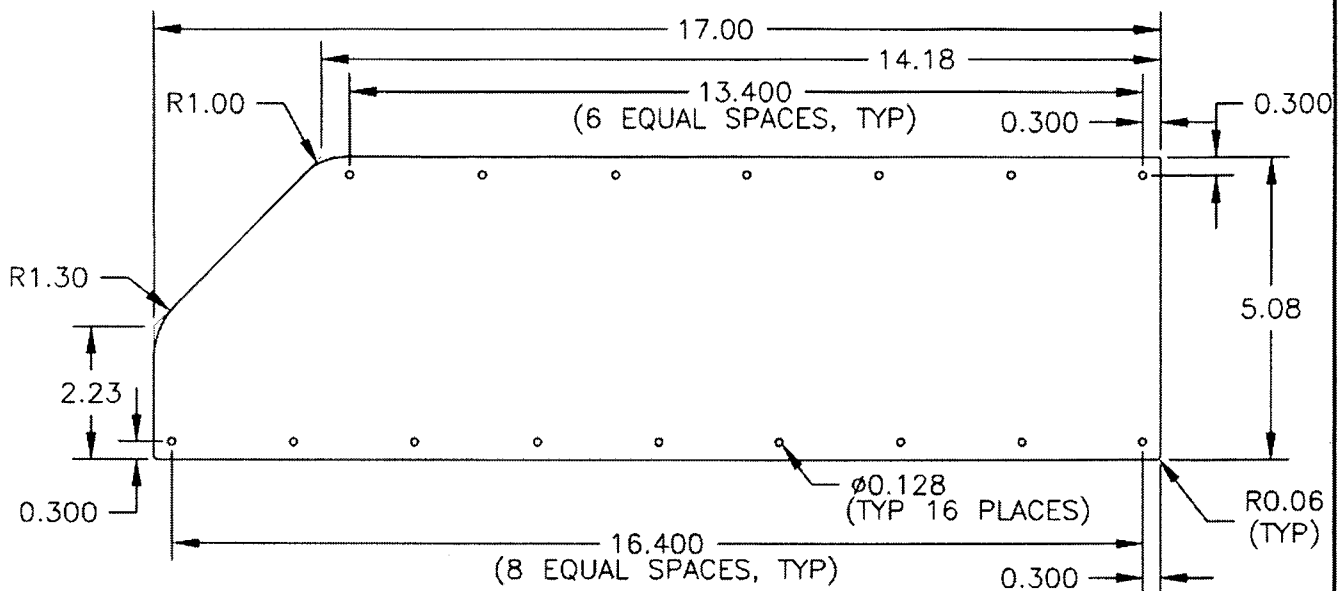
**D3296-1 DOOR ASSEMBLY**

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

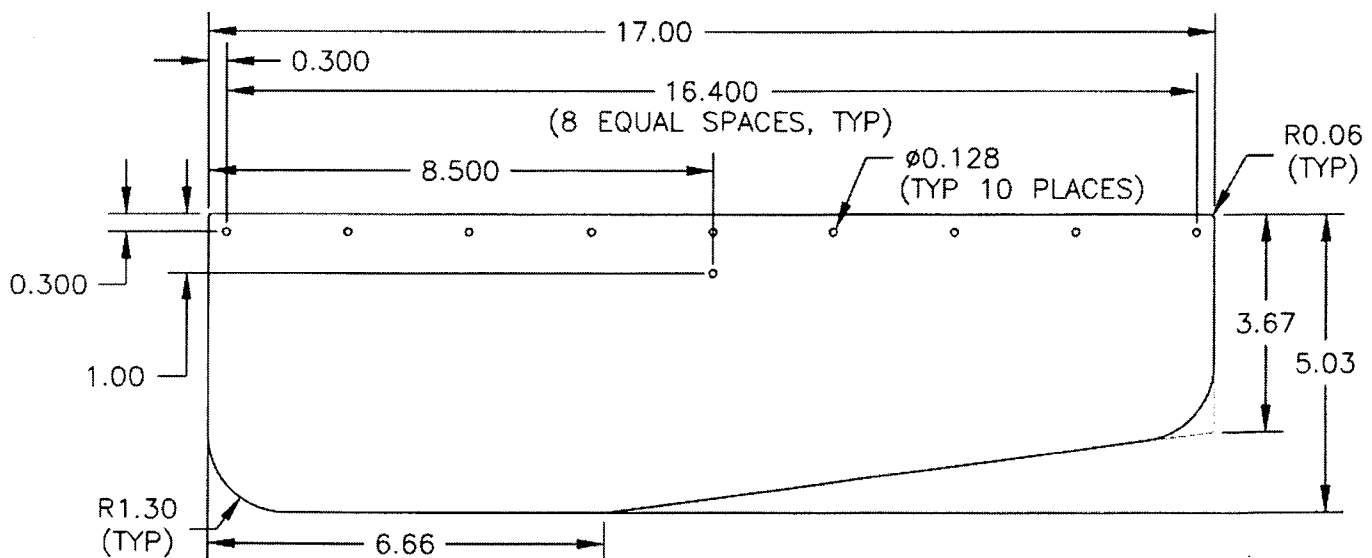
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



**D3296-1 DOOR PANEL**



**D3296-3 DOOR PANEL**

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK  
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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